

Date:  
User:

Tuesday, 03/02/2009 2:49:10 PM  
Julie Dawson

Grey

Dart Aerospace Ltd.

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 45477  
Estimate Number : 13771  
P.O. Number :  
This Issue : 03/02/2009 S.O. No. :  
Prsht Rev. : NC  
First Issue : / / Type : LARGE FAB ASSY  
Previous Run :  
Written By :  
Checked & Approved By : JLD 09-02-08  
Comment : Est Rev:A 09-02-03 new issue DD verified by:EC

Drawing Name : WEARPLATE  
Part Number : D3862041  
Drawing Number : D3862 REV.A  
Project Number : N/A  
Drawing Revision : A  
Material :  
Due Date : 20/02/2009 Qty: 8 Um: Each

(add 1 for jig Template)

### Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304S16GA

304/316 Sheet .063



Comment: Qty.: 0.9006 sf(s)/Unit Total : 5.4035 sf(s)

304/316 .063 Sheet

Batch: 189-2-5

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3862

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

189-2-5

189-2-5



3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

189-2-5

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

509/02/65 (x2)

5.0

D30093

Cup



Comment: Qty.: 6.0000 Each(s)/Unit Total : 36.0000 Each(s)

CUP

Batch: 2112376

18

48

BE 09/03/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 03/02/2009 2:49:10 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 45477

Part Number: D3862041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld D3009-3 cups as per dwg D3862

A/R 316L stainless steel rod

Batch:

*M 109213* *EL/BE* *09/03/19*

2-Weld hard facing as per Dwg D3862

A/R 2059B Hard Coat rod

Batch:

*M111036*

*EL* *9-3-20* *(X8)*

7.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*Op 09.03.23*

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 09/03/23* *(X8)*

9.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*M109648*

START TIME:

*10:30*

OVEN TEMPERATURE:

*320°*

FINISH TIME:

*11:00*

*BR 09-04-2*

*(8)*

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*09-04-02*

*(X8)*

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart P/N and B/N using a permanent fine point marker as indicated on dwg, then Stock

Location

*262*

*9/4/13*

*SD*

*(X8)*

12.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/04/06*

Job Completion



*MF 09-04-06*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

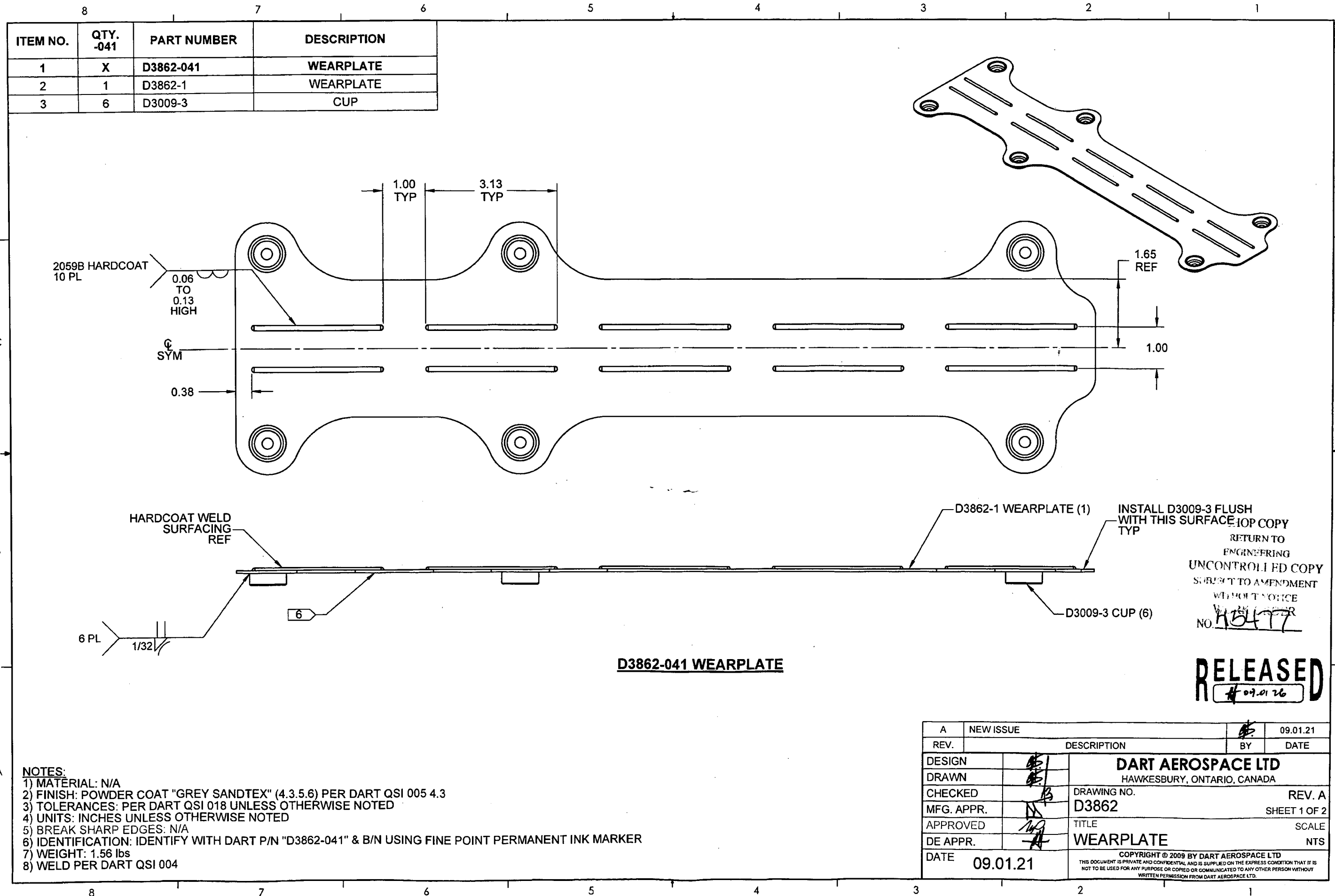
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

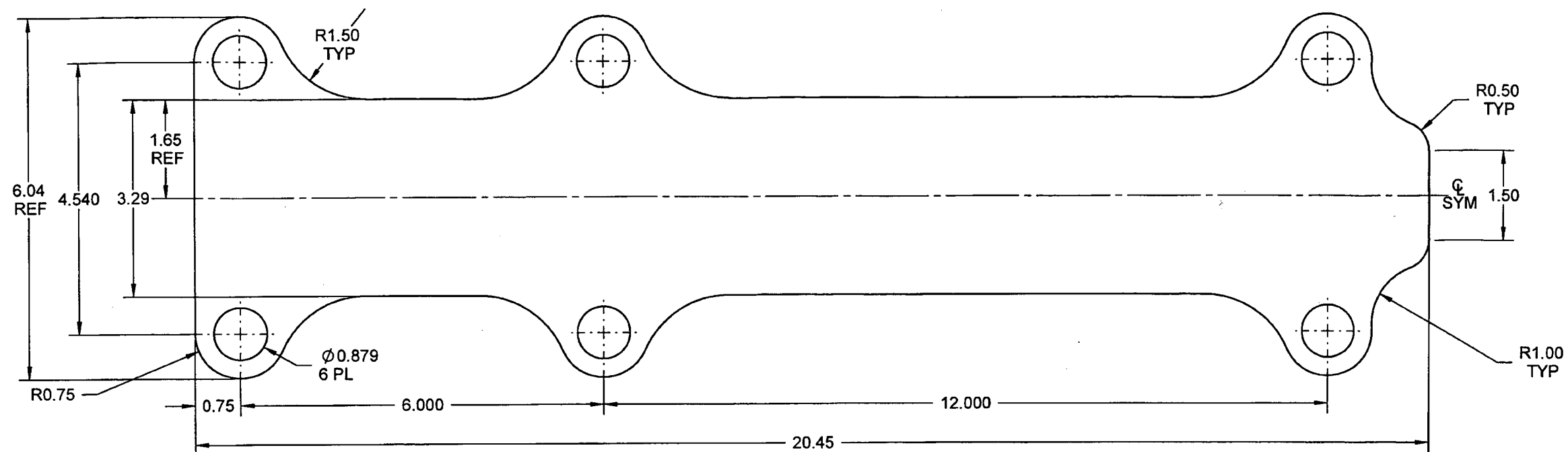
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries













# **D3862-1 WEARPLATE**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 45417

**RELEASED**  
# 09.01.26

## **NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK) PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 (REF DART SPEC M304S16GA)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.39 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3862</b>	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>WEARPLATE</b>	NTS
DATE	<b>09.01.21</b>	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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